

Date: Friday, 26/09/2008 10:58:26 AM
 User: Julie Lecocq











Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 42299		
Estimate Number	: 12956		
P.O. Number	:	Part Number	: D36392
This Issue	: 26/09/2008 S.O. No. :	Drawing Number	: D3639 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 34539	Material	:
Written By	:	Due Date	: 06/10/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUL 08.9.26</u>		
Comment	: Est Rev:A New Issue 07-07-20 JLM	Verified By:EC	

Additional Product

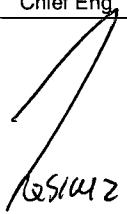
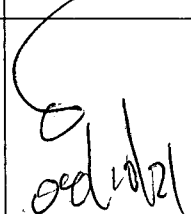
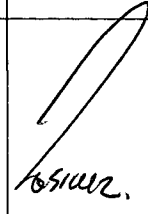
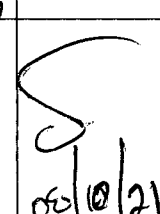
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3 .050 sheet
		
Comment: Qty.: 0.2510 sf(s)/Unit Total : 2.5095 sf(s) 2024-T3 .050 sheet Batch: <u>105646</u> <u>IB 8-10-20</u>		
2.0	WATER JET	FLOW WATER JET
		
Comment: FLOW WATER JET 1-Cut as per Dwg D3639 Dwg Rev: <u>A</u> <u>IB 8-10-20</u> Prog Rev: <u>A</u> 2-Deburr if necessary <u>IB 8-10-20</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>IB 8-10-20</u>		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK <u>S 08/10/20</u> <u>(x10)</u>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: SMALL & MEDIUM FAB RESOURCE 1 C'sink as per Dwg D3639 <u>N/A 08.10.21</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3639-2 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/10/23
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>42299</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/10/21	#2	one part flawed with a diagonal cut out from water jet. P.C. end of the plate material		Scrap and Destroy Qty ① no repl/nc	IB 8-10-21			

NOTE: Date & initial all entries

Date: Friday, 26/09/2008 10:58:26 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 42299

Part Number: D36392

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3639

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 57261

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08-10-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42299
Description: Doubler		Part Number: D3639-2
Inspection Dwg: D3639	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

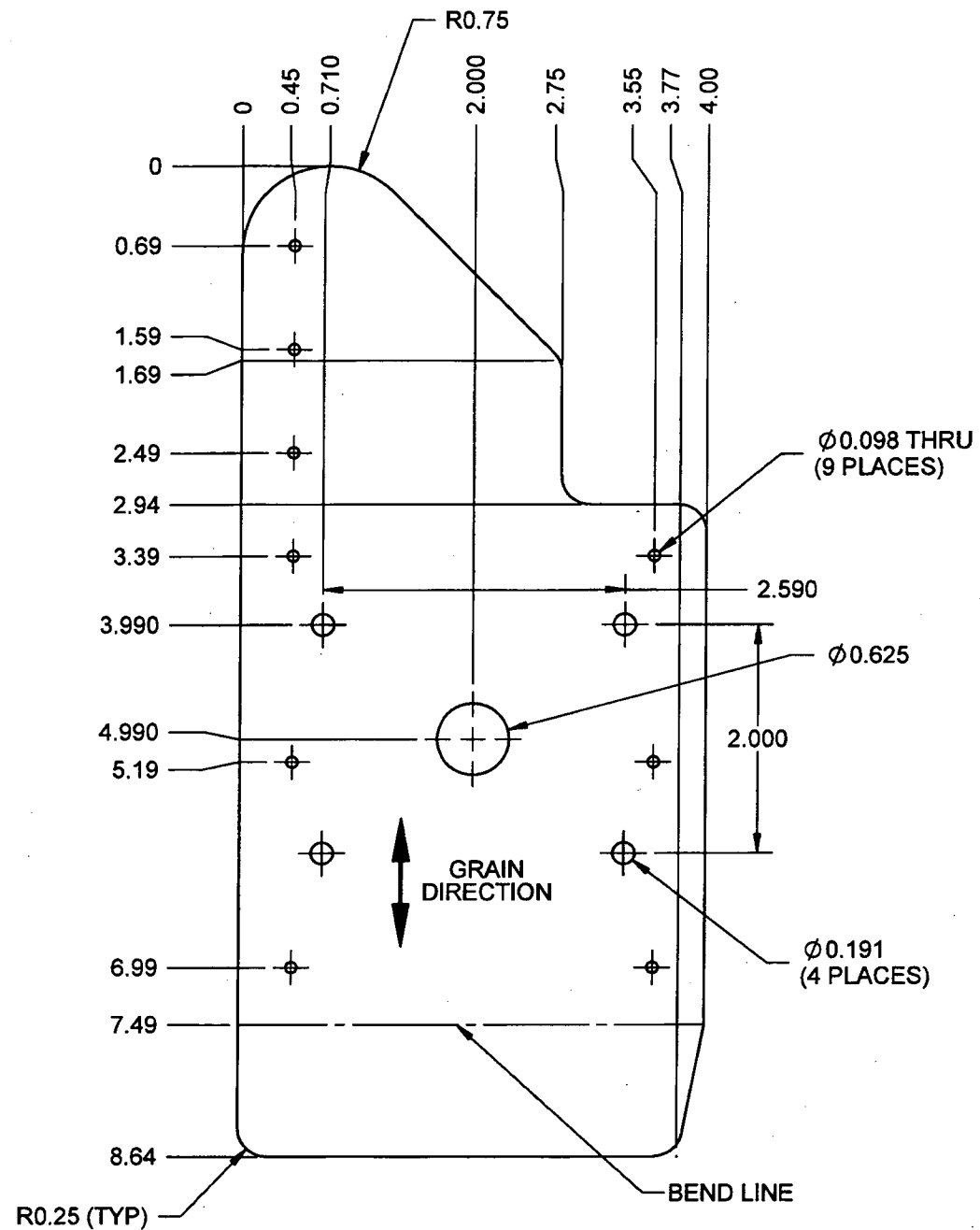
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.627	X			
Ø0.191	+0.005/-0.001	.192	X			
Ø0.098	+0.004/-0.001	.102	X			
0.69	+/-0.030	.688	X			
1.59	+/-0.030	1.585	X			
2.49	+/-0.030	2.49	X			
3.39	+/-0.030	3.389	X			
3.990	+/-0.010	3.992	X			
4.990	+/-0.010	4.990	X			
5.19	+/-0.030	5.19	X			
6.99	+/-0.030	6.99	X			
8.64	+/-0.030	8.64	X			
0.45	+/-0.030	.458	X			
0.710	+/-0.010	.714	X			
2.000	+/-0.010	2.003	X			
2.75	+/-0.030	2.756	X			
3.55	+/-0.030	3.56	X			
4.00	+/-0.030	4.009	X			
2.000	+/-0.010	1.998	X			
2.590	+/-0.010	2.593	X			

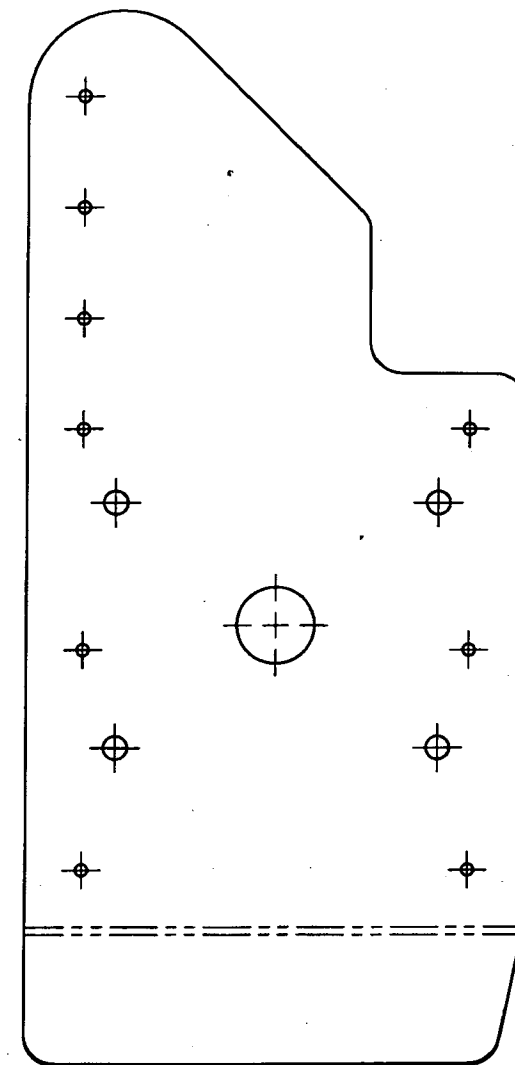
Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 8/10/20	Date: 08/10/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	

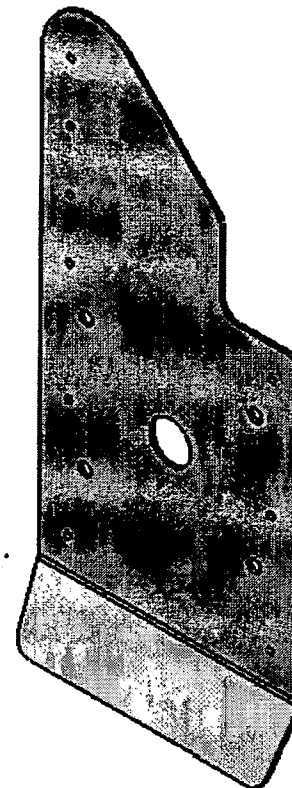
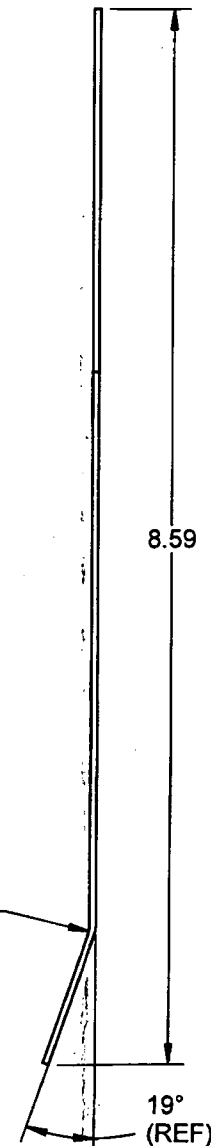
8 7 6 5 4 3 2 1



**D3639-1F FLAT PATTERN
(D3639-2F OPPOSITE)**



**D3639-1 DOUBLER
(WAS GENEVA P/N G10604-3)
D3639-2 OPPOSITE
(WAS GENEVA P/N G10604-6)**

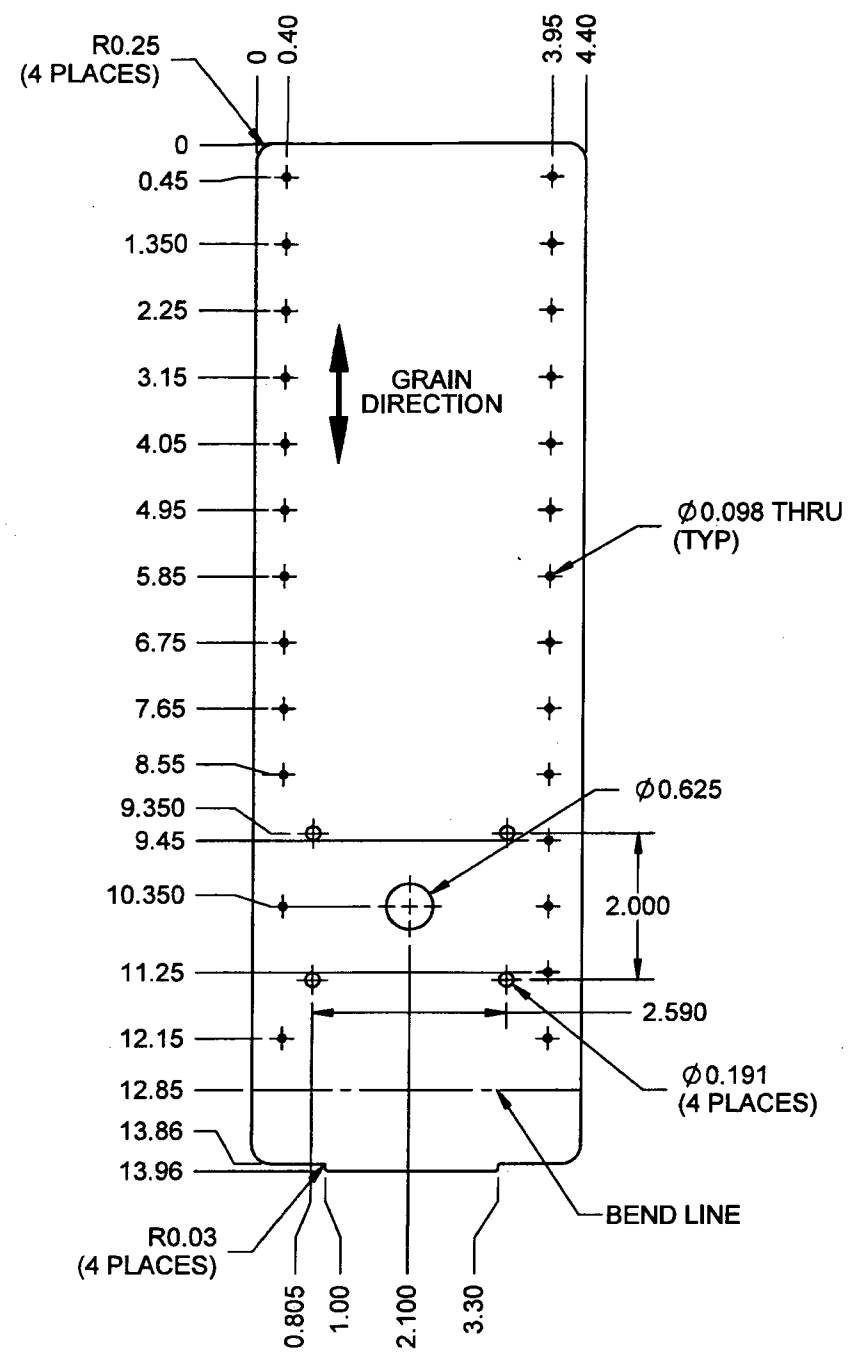


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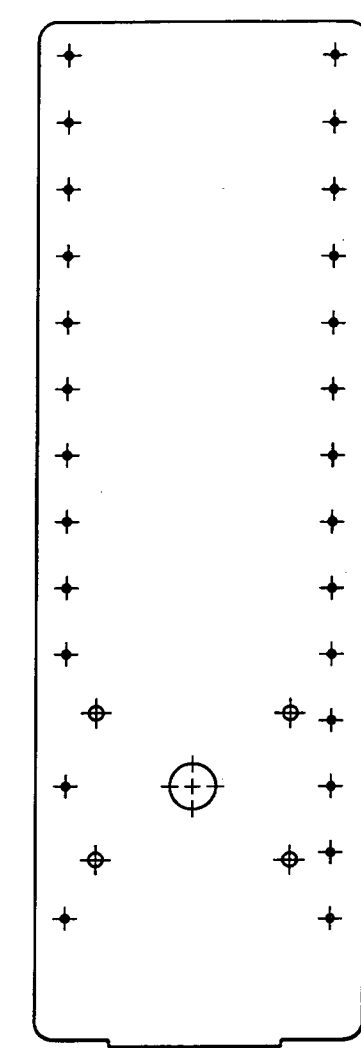
RELEASED
07.07.07

- NOTES:**
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.14 lbs

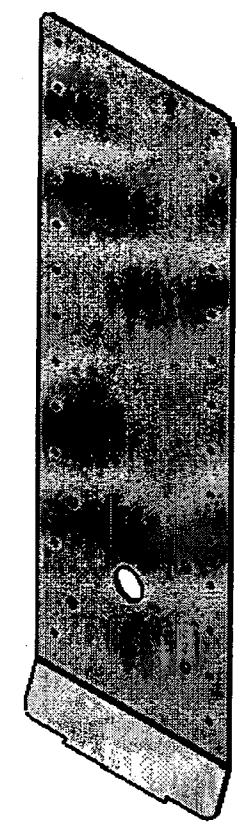
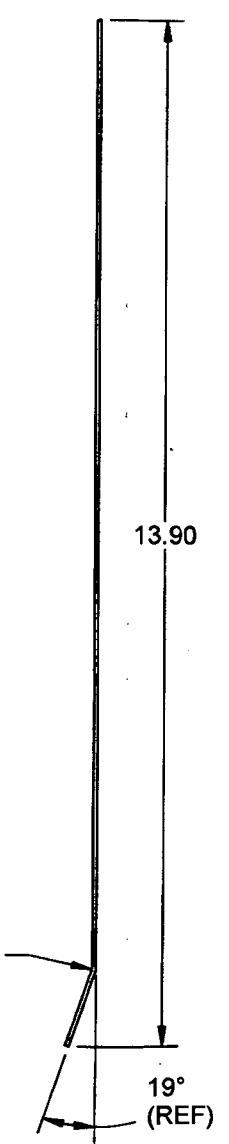
A	NEW ISSUE; REPLACES G10604	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	LE		
CHECKED	JB	DRAWING NO.	REV. A
MFG. APPR.	BE	D3639	SHEET 1 OF 2
APPROVED	NO	TITLE	SCALE
DE APPR.	TH	DOUBLER	2:3
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D3639-3F FLAT PATTERN
(D3639-4F OPPOSITE)



D3639-3 DOUBLER
(WAS GENEVA P/N G10604-4)
D3639-4 OPPOSITE
(WAS GENEVA P/N G10604-5)



- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	CE	PORT HADLOCK, WA	
CHECKED	EB	DRAWING NO.	REV. A
MFG. APPR.	EB	D3639	SHEET 2 OF 2
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DE APPR.	EB	DOUBLER	2:5
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